

Split

Dart Aerospace Ltd.

Wednesday, 12/14/2005 2:24:22 PM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARING ASSEMBLY
Job Number : 25225 -1	
Estimate Number : 10716	
P.O. Number : N/A	Part Number : D3121241
This Issue : 12/14/2005 S.O. No. : N/A	Drawing Number : D3121 REV C2
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : C2
Previous Run : 24777	Material : N/A
Written By : See comment below	Due Date : 12/21/2005 Qty: 79 Um: Each
Checked & Approved By : See comment below	
Comments : Est Rev: A 04.02.18 New issue KJ/DS	

Product

ber:



# Machine Or Operation: Description :

1.0 MDELINR12500 DELRIN ROUND BAR 1.25"



Comment: Qty.: 0.0431 f(s)/Unit Total: 0.8610 f(s)

Material: Ø1.25 Delrin Rod

(M-DELIN-R1.2500) Identify as D3121-25

Batch: N/A

MS 05/12/21

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn D3121-25 Cap as per Folio FA387

MS 05/12/21

79

2-Deburr

MS 05/12/21

79

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 05/12/21

79

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

MS 05/12/21

79

5.0 D312123 Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3121-23

Bearing

B24558 (10x) B25340 (40x) DL 06/04/09 50

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING ASSEMBLY

Job Number: 25225

Part Number: D3121241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121

DL 06/01/09

50

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-01-05

49  
PTO

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 401

C 206/01/09

49

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SAC 06/01/10 49

06/01/10

49

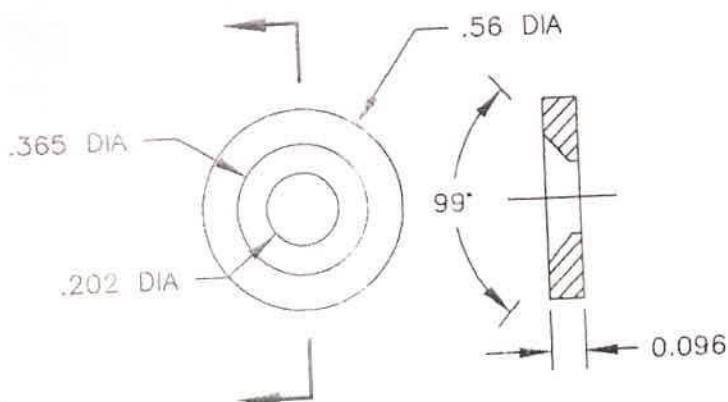
Job Completion





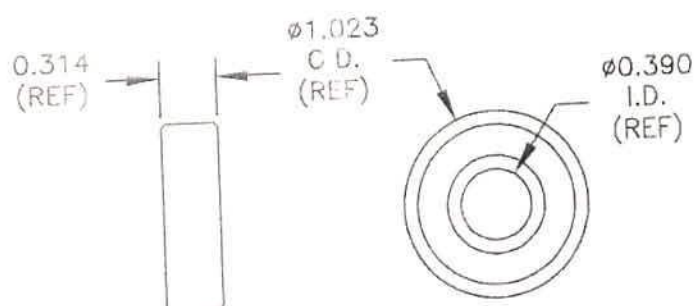


DESIGN	DRAWN BY	DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D3121	SHEET 10 OF 10
DATE		TITLE	SCALE
04.02.17		BRACKET ASSEMBLY	1:1



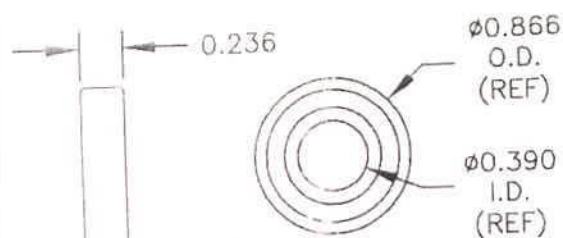
#### D3121-17 WASHER (SCALE 2:1)

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



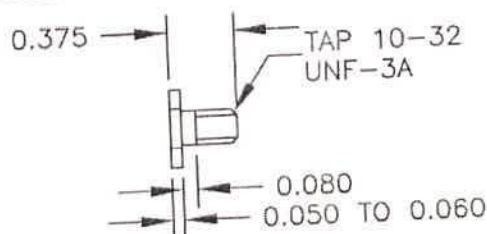
#### D3121-19 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM  
FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES



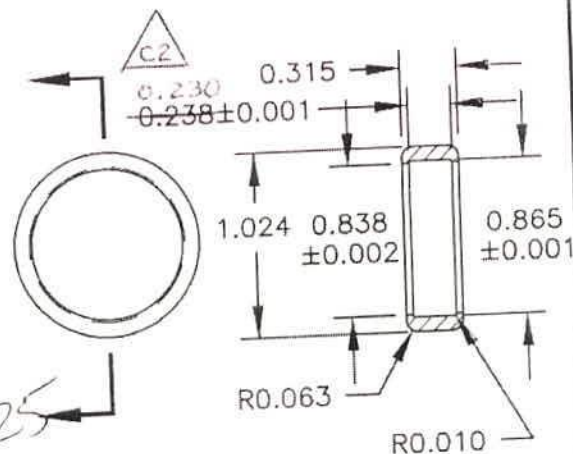
#### D3121-23 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z  
OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES



#### D3121-21 BOLT (SCALE 1:1)

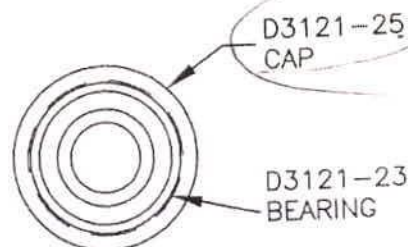
- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



#### D3121-25 CAP (SCALE 1:1)

- 1) MATERIAL: DELRIN ROD, 1.25 (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

RELEASED  
04.03.01



#### D3121-24 BEARING ASSEMBLY (SCALE 1:1)

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☒ DQA: ☒ Date: 06/01/10

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-01-09	6	1 bearing scrapp. bearing has dent from pressing and doesn't role good.	<i>[Signature]</i>	Scrap: destroy	<i>[Signature]</i> 06-01-09	<i>[Signature]</i> 06-01-09	<i>[Signature]</i>	<i>[Signature]</i> 06-01-09

NOTE: Date & initial all entries